

# Work Order ID 71216

Friday, June 24, 2011 10:41:26 AM



Page 1

Item ID: D2656-15

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 6/24/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/27/2011 Req'd Qty: 4.00



Customer:

Ship 29th or  
soonest

Reference:

Run Start



Approvals: Process Plan: JMC Date: 11-06-24 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2656	Rev D								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2656 ☐ Dwg Rev: D ☐ Prog Rev: D ☐ 2-  
Debur if necessary

11-6-07

(4)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

11-6-07

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8/6/27

(4)

**Work Order ID 71216**

Friday, June 24, 2011 10:41:26 AM



Page 2

Item ID: D2656-15

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 6/24/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/27/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



Brake NC

NC BRAKE

0.00

Memo

0.00

1-Form on Brake as per Dwg D2656 using Jigs DT8261 and DT8326 2-Form  
joggle as per Dwg D2656 using Jig DT8158 3-Identify as D2656-15

SB 11/06/27

(4)

140



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

S 11/06/27

(4)

Quality Control

150



Powdercoat

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Memo

0.00

START TIME: \_\_\_\_\_ □OVEN TEMPERATURE:  
□FINISH TIME: \_\_\_\_\_

8:30

3:20

9:00

4X 11/06/28

M 11/5/28

**Work Order ID 71216**

Friday, June 24, 2011 10:41:26 AM



Page 3

Item ID: D2656-15

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 6/24/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/27/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

4 0 11/06/29

170

Identify as per dwg & Stock Location: FP

0.00



Packaging

Memo

0.00

Packaging

6 JB (4) 11/06/29

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/06/29

11/06/29 (4)

# Picklist Print

Friday, June 24, 2011 10:41:23 AM

Page 1

Work Order ID: 71216



Parent Item: D2656-15



Parent Item Name: Wearshoe

Start Date: 6/24/2011

Required Date: 6/27/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: D 02.10.25 Re-format KJ  
IPP Rev:E Now on Waterjet 06-09-25 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M1010S20GA

Purchased

No

100

sf

157.0000

0.6125

2.578947



1010/1025 SHEET

B11-6-27

Location

Loc Qty

Loc Code

MAT019

157

111410

64

116791

93

116791

4

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 71216
<b>Description:</b> Wearshoe		<b>Part Number:</b> D2656-15
<b>Inspection Dwg:</b> D2656	<b>Rev:</b> D	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
39.150	+/-0.010	39.150	L		T B01	
35.650	+/-0.010	35.650	>		T	
33.650	+/-0.010	33.650	L		T	
30.150	+/-0.010	30.150	>		T	
24.900	+/-0.010	24.900	>		T	
19.650	+/-0.010	19.650	A		T	
14.400	+/-0.010	14.400	>		T	
9.150	+/-0.010	9.150	X		T	
5.650	+/-0.010	5.650	X		T	
2.000	+/-0.010	2.003	>		V B02	
1.885	+/-0.010	1.890	>		V	
0.300	+/-0.010	.303	>		V	
0.300	+/-0.010	.302	>		V	
0.040	+/-0.010	.037	X		V	

<b>Measured by:</b> JB	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 11-6-27	<b>Date:</b> 11/6/27	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	07.07.18	New Issue	KJJ/JLM	JE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

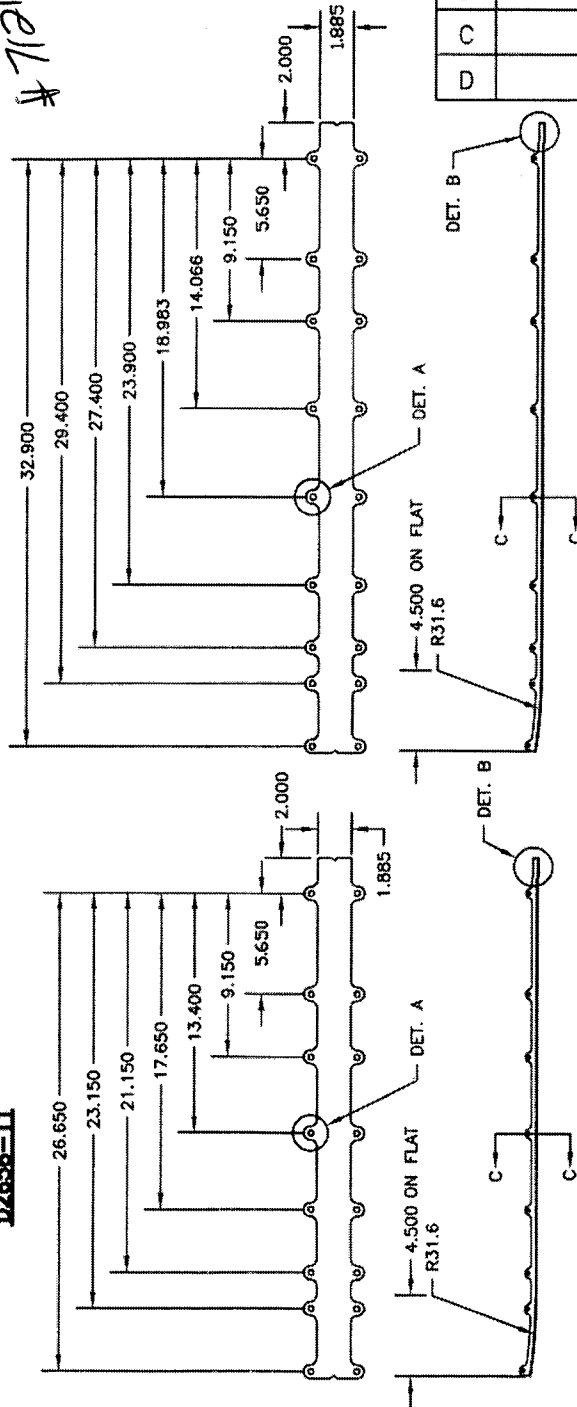
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

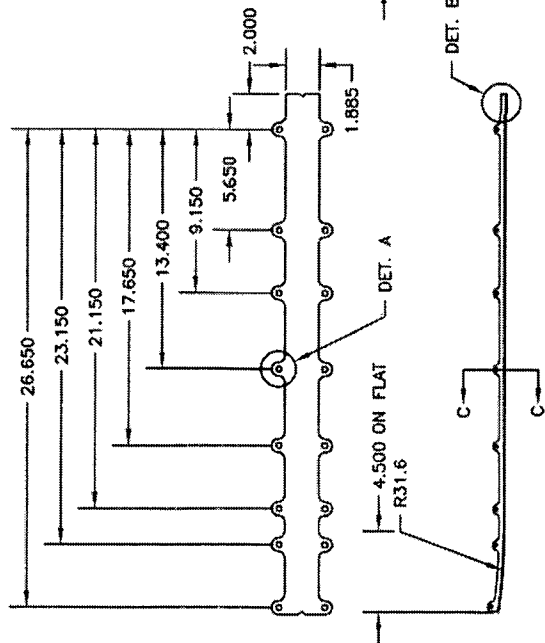


DESIGN	DS	DRAWN BY	CP	DART AEROSPACE USA, INC.	
				PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	REV. D
				D2656	SHEET 1 OF 4
DATE	05.08.17			TITLE	SCALE
				WEARSHOE	1:10
A	97:03:25	NEW ISSUE			
B	97:06:02	CHANGED TABS			
C	97:06:26	R31.6 WAS R19.5			
D	05.08.17	ENLARGE ALL HOLES TO IMPROVE FIT			

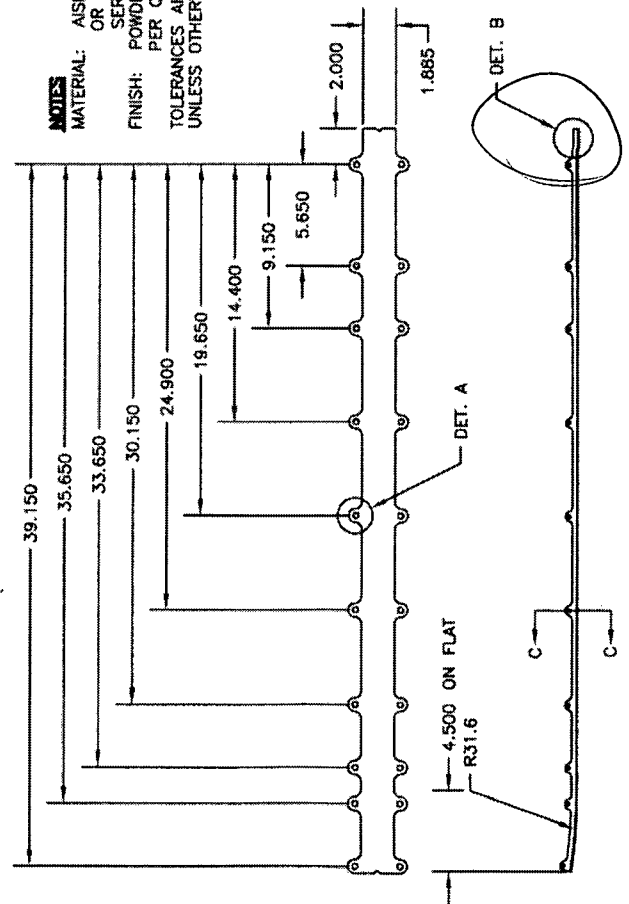
D2656-13



D2656-11



D2656-15



**NOTES**  
 MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008  
 OR CSA G40-21, 38W/44W/50W/60W/70W  
 SERIES STEEL, 20 GAUGE (0.040 THICK)  
 FINISH: POWDER COAT GREY SANITEX (4.3.5.6)  
 PER QSI 005 4.3  
 TOLERANCES ARE PER DART QSI 018  
 UNLESS OTHERWISE NOTED

RELEASED  
 05-09-08

Copyright © 1997 by DART AEROSPACE USA, INC.

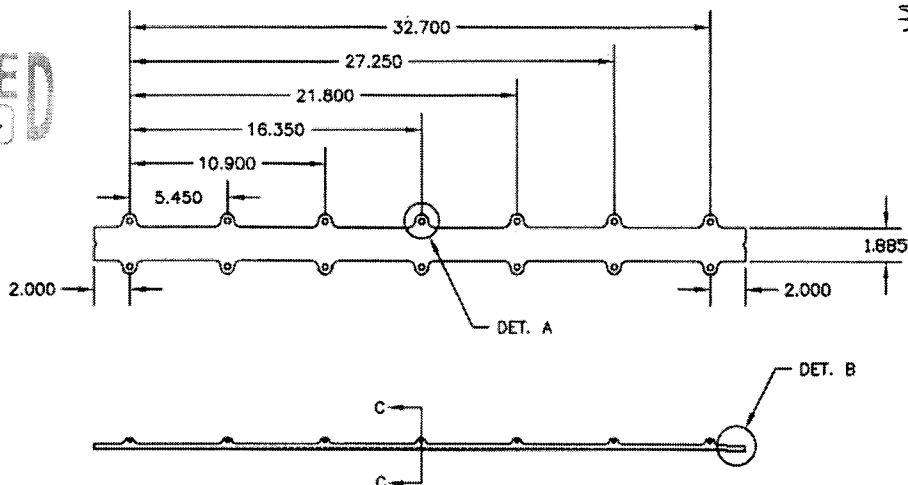
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.



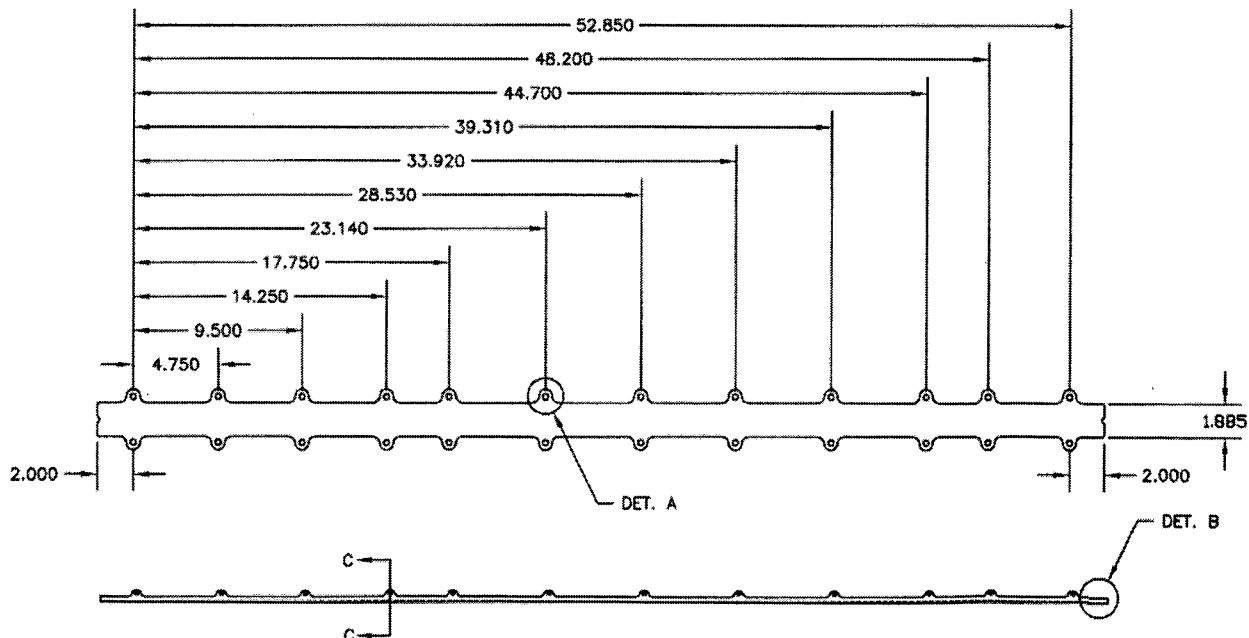
DESIGN	DS	DRAWN BY	CP	DART AEROSPACE USA, INC.	
				PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	REV. D
				D2656	SHEET 2 OF 4
DATE	05.08.17			TITLE	SCALE
				WEARSHOE	1:10

RELEASED  
05.09.06

### D2656-21



### D2656-23



#### NOTES

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W  
SERIES STEEL, 20 GAUGE (0.040 THICK)  
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018  
UNLESS OTHERWISE NOTED

Copyright © 1997 by DART AEROSPACE USA, INC.

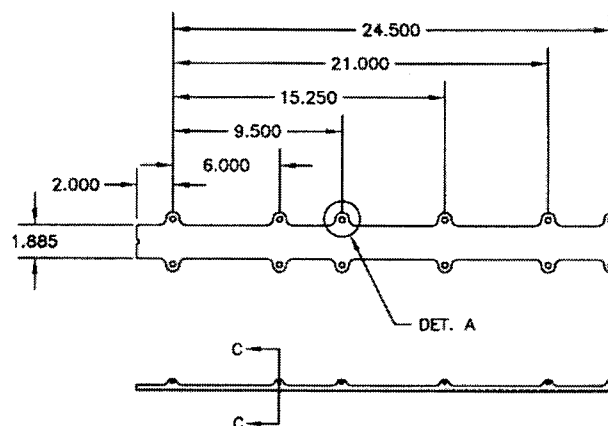
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.



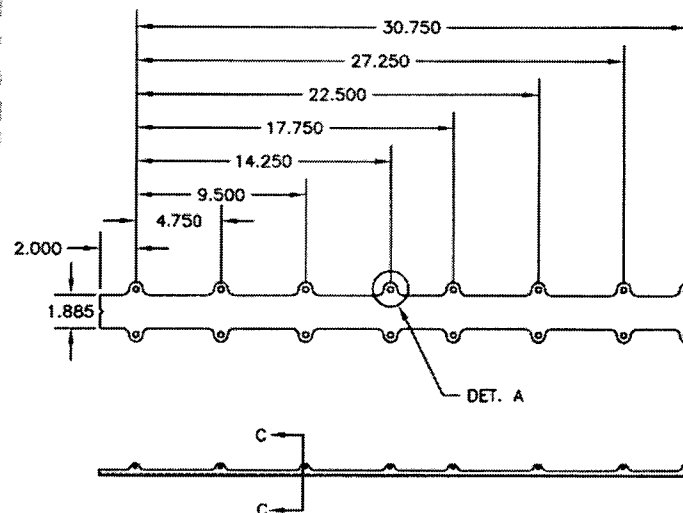


DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
DS	CP	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. D
#	#	D2656	SHEET 3 OF 4
DATE	TITLE	SCALE	
05.08.17	WEARSHOE	1:10	

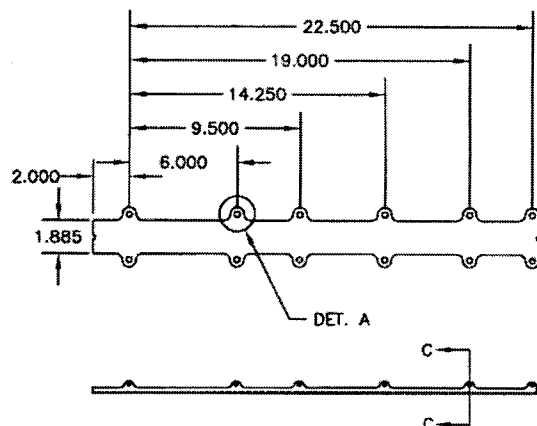
D2656-33



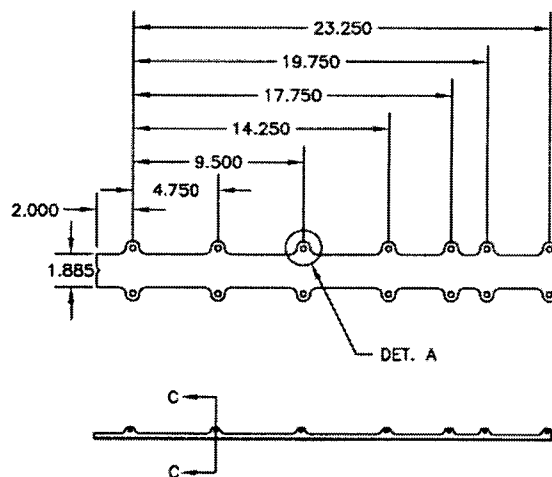
D2656-37



D2656-31



D2656-35



NOTES

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W  
SERIES STEEL, 20 GAUGE (0.040 THICK)  
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018  
UNLESS OTHERWISE NOTED

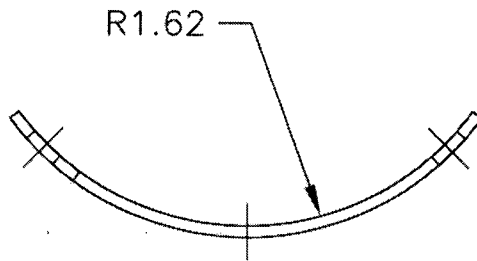
RELEASED  
05.07.06

#71216



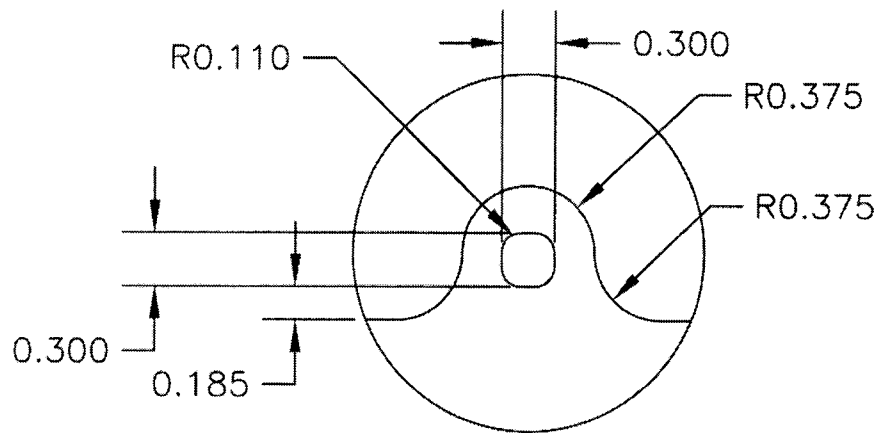
DESIGN DS	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2656	REV. D SHEET 4 OF 4
DATE 05.08.17	TITLE WEARSHOE		SCALE 1:10

### SECTION C-C

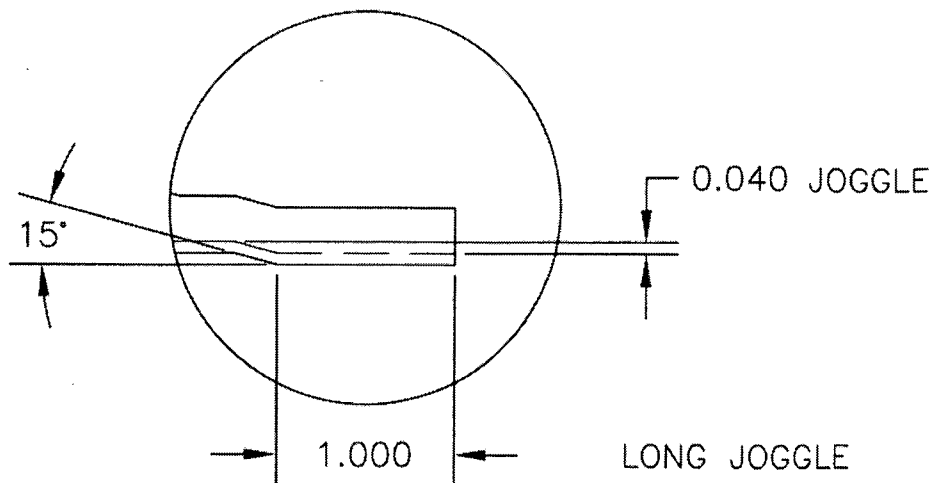


RELEASED  
05.09.06  
91211 #

### DETAIL A



### DETAIL B



Copyright © 1997 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.